

Date:  
User:Friday, 12/12/2008 10:36:39 AM  
Julie Dawson

## Process Sheet

Split 20801-23

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : FWD TUBE ASSEMBLY

Job Number : 44041 -2

Estimate Number : 10467

P.O. Number :

This Issue : 12/12/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SKIDTUBES

Previous Run : 41841

Part Number : D3391021

Drawing Number : D3391 REV H

Project Number : N/A

Drawing Revision : H

Material :

Due Date : 19/12/2008

Qty: 7 Um: Each

Written By :

Checked &amp; Approved By :

Comment :

: Est. A 05.09.13 New issue KJ/JLM

Est. B 06.02.10 Dwg rev.D ecn 773 EC

Est. C 06.05.02 Added inspections EC

est D 07.03.13 rev F dwg EC

est E 07.11.07 revG dwg ecn1053P EC verified by: DD

Est Rev:f ECN 1056 07-11-12 DD verified by: EC

Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

Est Rev:H 08-09-10 revH as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6013047

Skidtube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description
1	D6013-047	Extrusion

Batch

B-23935① - AWM

B-26547 X6

8-12-15

2.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



AWM

8-12-15



Comment: LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: Nc bender

Bend as per Dwg D3391 Using Bend Prog 3391021

SL 8-12-15

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15





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Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. \_\_\_\_ & Dwg D3391 Rev. \_\_\_\_  
Identify as D3391-1

⑦

2-Deburr

*mmf 09/01/09*

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mmf 09/01/09* ⑦

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

*HA 09/01/12*

⑦

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*HA 09/01/12*

⑦

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*J.L 09/01/12*

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

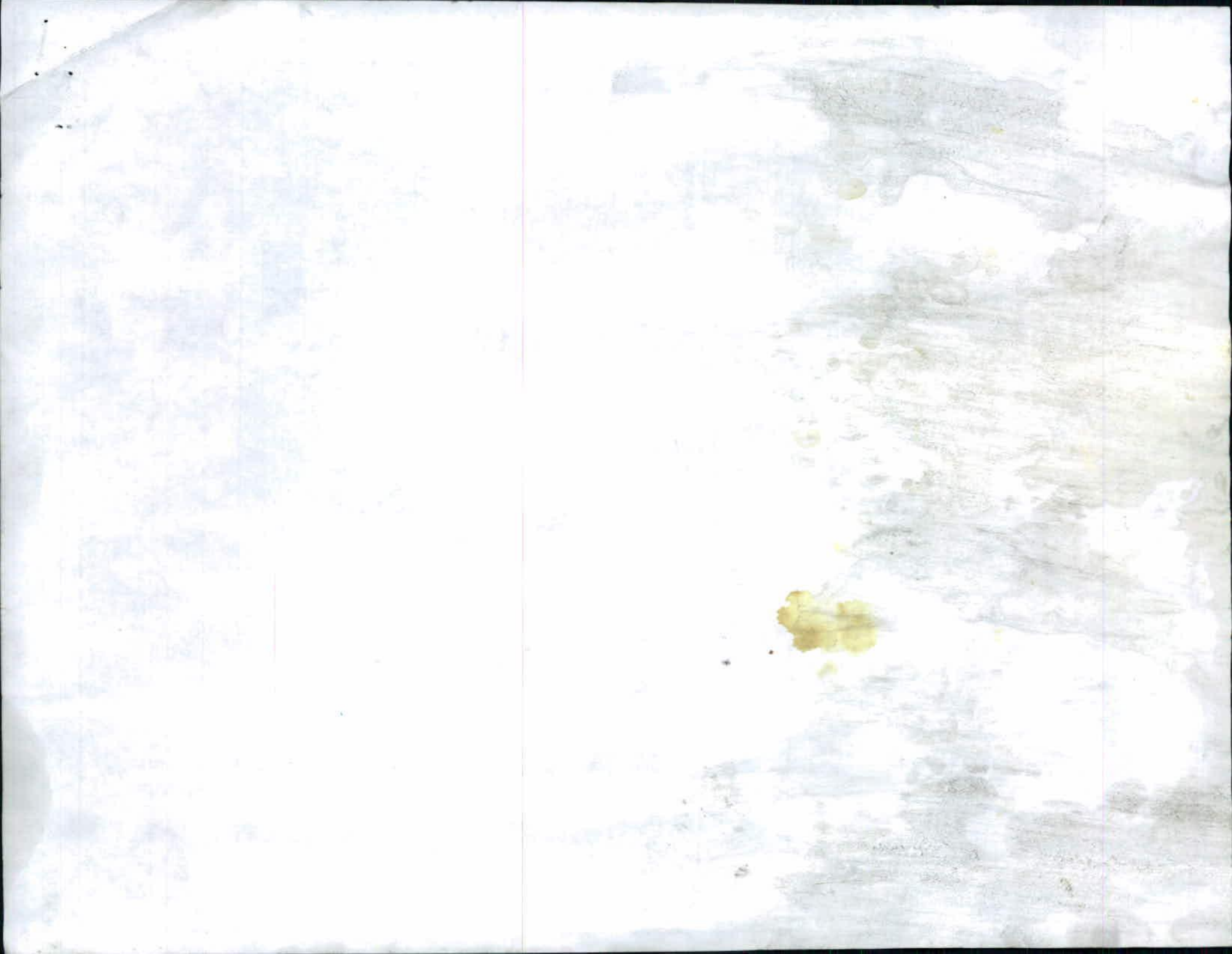
5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

*M 9-3-12*

*9-1-14*





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Job Number: 44041

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/18 (40)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MA 09-03-18 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 09-3-18

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

SPACER

batch:

B41863 (1) B46106 (3) MA 9-3-19 (3)

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch:

exp. date: 9-9-19

cure time 12hrs. as per QSI015

M107900 MA 9-3-19

2- grind crossbolt flush

) MA 9-4-1

3-back drill crossbolt if necessary

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlarla (1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Pressure Wash 09-04-01 x1 set  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939

START TIME:

7:45

OVEN TEMPERATURE:

320°

MA 09-04-1 (1)

Date: Friday, 03/04/2009 8:39:39 AM  
User: Ghantal Lavoie

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Job Number: 44041

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

SIISA

BR

09-04-01 (X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-03 (X)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

NA



20.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

\*\*\*\* install D3591-1 spacer as per DSI9364 \*\*\*\*

gl

09-04-06 (X)

21.0

ALS41032130

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Insert M108606

gl

\*

22.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Insert M119393

gl

\*

23.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Gasket B45717

gl

24.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Wearshoe B478409

gl

25.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Tow Cap Assembly B41931

gl

09-04-03 (X)



Date: Friday, 03/04/2009 8:39:39 AM  
User: Chantal Lavoie

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Job Number: 44041

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C4A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

BOLT

M111279

HS

\*

27.0

AN960C10L

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

washer

M111193

HS

\*

28.0

D36721

Phenolic Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Phenolic Washer

13 39275

HS

09-01-02

VD

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13

Job Completion



W09-04-06

#28.1

inspect to current step

QCS → 8446

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 44041

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

8:45

15K 09-04-2

(1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-03

(2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1

28.2



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O 44041 K

20.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

\*\*\*\* install D3591-1 spacer as per DSI9364 \*\*\*\*

41

09-04-06

(X1)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O 44041

4201

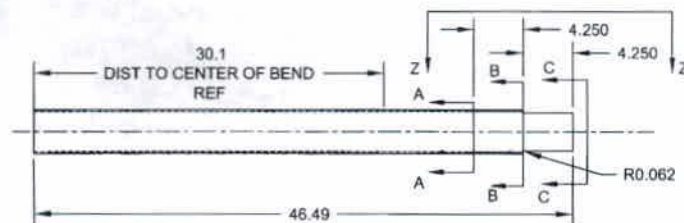
ACS inspect work to current step  
8/1/16

PP1 96 801 09/4/13

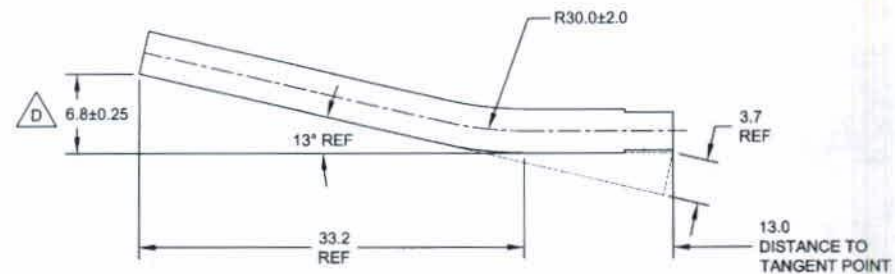




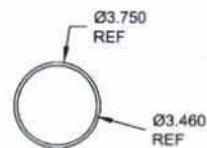




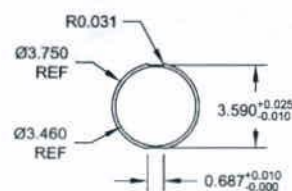
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



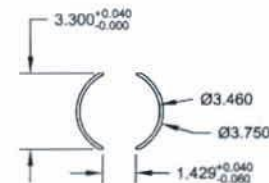
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



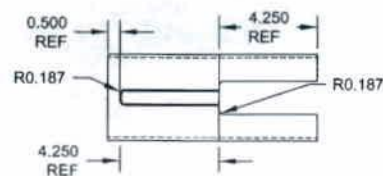
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

**RELEASED**  
08-05-11

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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44041

